

Date: Monday, 5/1/2006 1:51:00 PM
 User: Kim Johnston

Process Sheet

| | |
|---|---|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : 206L BASKET LID |
| Job Number : 26878B | |
| Estimate Number : 11274 | |
| P.O. Number : N/A | Part Number : D2252043 |
| This Issue : 5/1/2006 S.O. No. : N/A | Drawing Number : UNDER REVIEW <i>pp06.05.02</i> |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : N/A Type : LARGE FAB ASSY | Drawing Revision : E |
| Previous Run : 26877B | Material : N/A |
| Written By : <i>See Comment Below</i> | Due Date : 5/20/2006 Qty: 1 Um: Each |
| Checked & Approved By : <i>06.05.01</i> | |
| Comment : Est Rev:1 REVISED AS PER REV E 05-12-06 JLM | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|----------------|--------------------------|
| 1.0 | M304TS0750W065 | 304 SQ Tube.75x.75x.065W |
|-----|----------------|--------------------------|



Comment: Qty.: 32.5539 f(s)/Unit Total : 32.5539 f(s)
 3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Batch: *H100783(43") H100748*

PD

06-05-08

| | | |
|-----|-------------|------------------------------|
| 2.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
|-----|-------------|------------------------------|



Comment: LARGE FABRICATION RESOURCE 1

1- Cut D2252-1-3-9 as per Dwg D2252

2-Drill hole in D2252-1 as per Dwg D2252

3-Deburr & Remove all Markings from Material

PD

06-05-08

| | | |
|-----|-------|-------------|
| 3.0 | D2329 | Label Plate |
|-----|-------|-------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|----------------|
| 1 | D2329 | Label Plate | <i>B248190</i> |

PD

06-05-08

| | | |
|-----|--------|----------------|
| 4.0 | D23271 | Spacer Bushing |
|-----|--------|----------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|---------------|
| 1 | D2327-1 | Bushing | <i>B24813</i> |

PD

06-05-08

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 5/1/2006 1:51:00 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L BASKET LID

Job Number: 26878B

Part Number: D2252043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D22321

Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2232-1

HINGE

B25238

PD

06-05-08

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2581

Mounting Chancel

B26204

PD

06-05-08

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 18.9000 sf(s)/Unit Total : 18.9000 sf(s)

Pick:

Qty Part Number

Description

Batch

18 sf

M304EX0.75-16F Expanded Metal

M100722

PD

06-05-11

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2252 using Welding Table and corner Jig

Deburr as required

A/R SS ROD

Batch: M100372

PD

06-05-15

9.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

11-06-05-18

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m

06-05-25

①

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: DP Date: 06/05/30
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 5/1/2006 1:51:00 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L BASKET LID

Job Number: 26878B

Part Number: D2252043

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



605-29 ①

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

M/A

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP060/05/30 ①

Job Completion



U 06-05-30

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries



RELEASED
05.11.26

| | | | |
|------------------|----------------|--|------------------------|
| DESIGN KE | DRAWN BY MB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D2252 | REV. E SHEET 1 OF 5 |
| DATE 05.11.10 | | TITLE BASKET ASSEMBLY (206L) | SCALE NTS |
| C | 95.12.11 | RE-DRAWN | |
| D | 99.09.14 | MODIFIED LATCH, D2581 WAS D2255-3 | |
| E | 05.11.10 | D2253-1 WAS D2253 (NCR 533), ADDED MEMBERS TO LID FRAME, ADDED D2232-1/-3 & D2252-19 | |

E

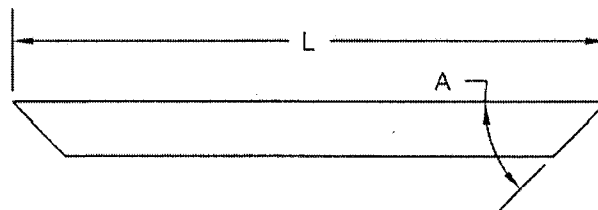
E

E

| Qty -041 | Qty -043 | Part Number | Description | L | A |
|-------------|-------------|-------------|------------------------|-------|----|
| X | | D2252-041 | BASKET ASSEMBLY | | |
| | X | D2252-043 | LID ASSEMBLY | | |
| | 2 | D2232-1 | HINGE | | |
| 2 | | D2232-3 | HINGE | | |
| 5 | | D2235-1 | RIB | | |
| 2 | 2 | D2252-1 | FRAME | 25.50 | 45 |
| 2 | | D2252-3 | FRAME | 96.00 | 45 |
| | 2 | D2252-7 | FRAME | 24.00 | 90 |
| 1 | | D2252-9 | FRAME | 10.25 | 90 |
| 1 | | D2252-11 | FRAME | 25.00 | 90 |
| 1 | | D2252-13 | FRAME | 42.00 | 90 |
| 1 | | D2252-15 | FRAME | 15.00 | 90 |
| 4 | | D2252-17 | FRAME | 19.78 | 53 |
| | 2 | D2252-19 | FRAME | 95.27 | 45 |
| | 2 | D2252-21 | FRAME | 30.82 | 90 |
| | 1 | D2252-23 | FRAME | 30.62 | 90 |
| 2 | | D2253-1 | LUG | | |
| 2 | | D2254 | GUSSET | | |
| | 1 | D2327-1 | BUSHING | | |
| 1 | | D2327-3 | BUSHING | | |
| | 1 | D2329 | LABEL PLATE | | |
| 4 | 2 | D2581 | MOUNTING CHANNEL | | |
| A/R | A/R | | 3/4-16F EXPANDED METAL | | |

NOTES:

1. MATERIAL: AISI 304/316 SS 3/4 X 3/4 X 0.060 WALL SQUARE TUBE
(REF. DART SPEC. M304TS0.750W.060)
2. FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3. WELD PER DART QSI 004
4. ALL DIMENSION ARE IN INCHES
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



CUT SIZE DETAIL

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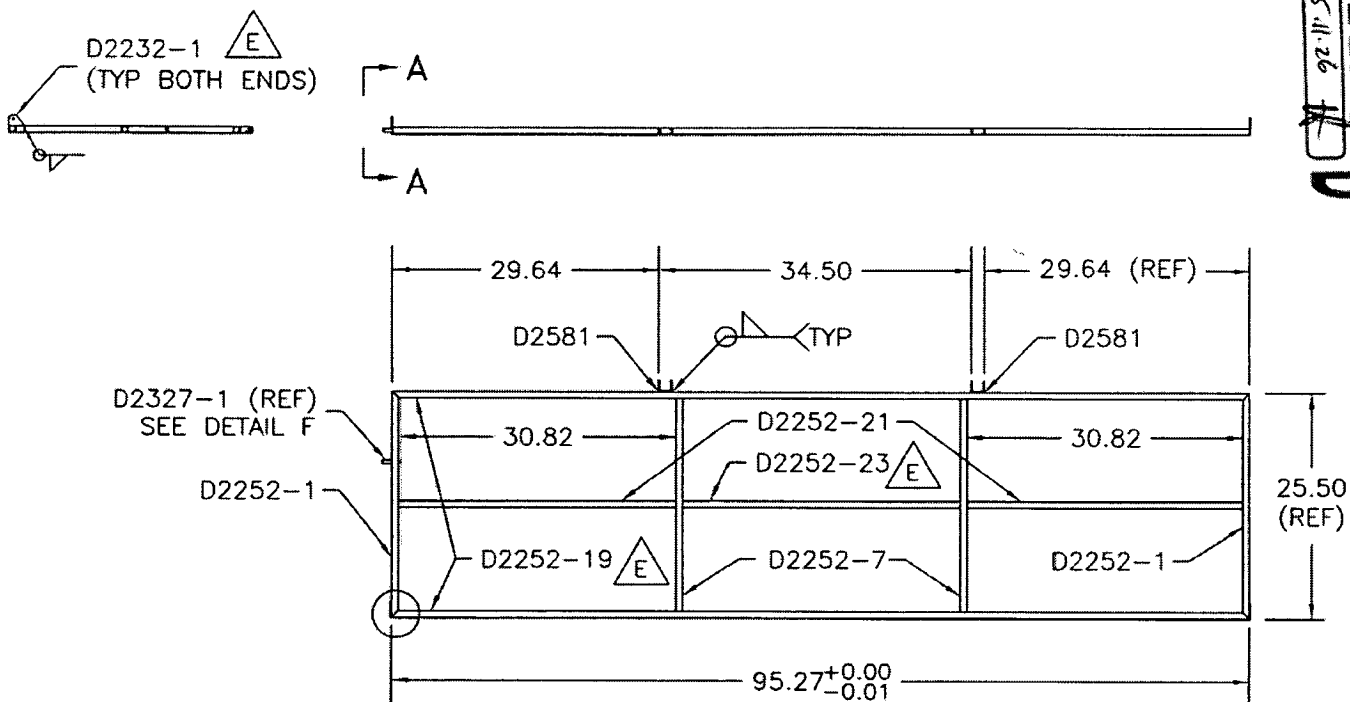
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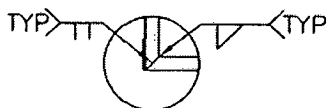
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| DATE | 05.11.10 | TITLE | D2252 | SHEET 2 OF 5 |
| | | | BASKET ASSEMBLY (206L) | SCALE NTS |

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D2252-043 LID FRAME



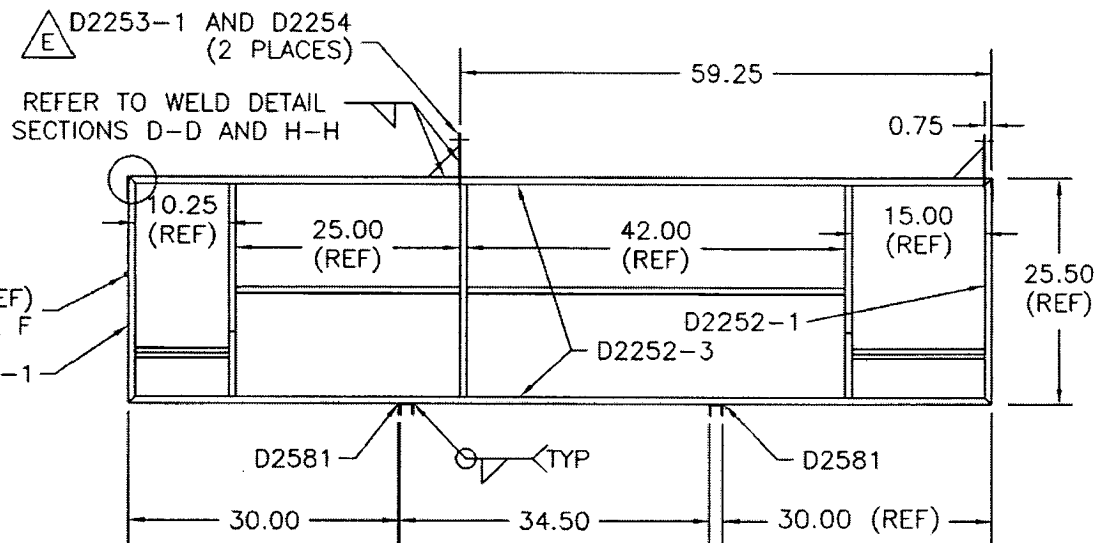
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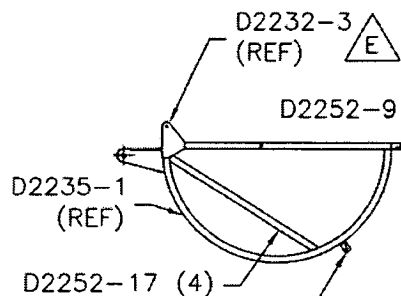
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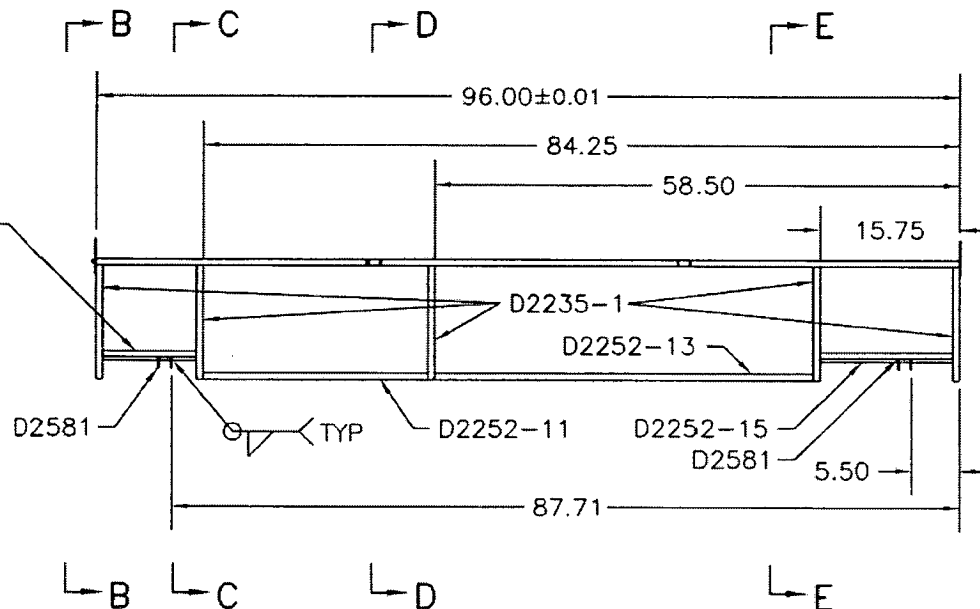
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| | | TITLE | BASKET ASSEMBLY (206L) | SHEET 3 OF 5 |
| | | | | SCALE |
| | | | | NTS |



WELD ALL JOINTS
AS SHOWN



WELD D2581
WITH LARGE HOLE
ON THIS SIDE



D2252-041 BASKET FRAME

RELEASED
05-11-26

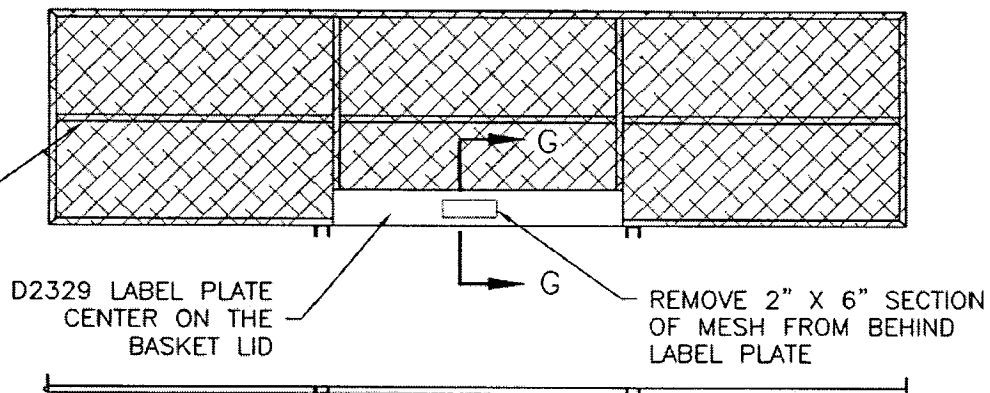
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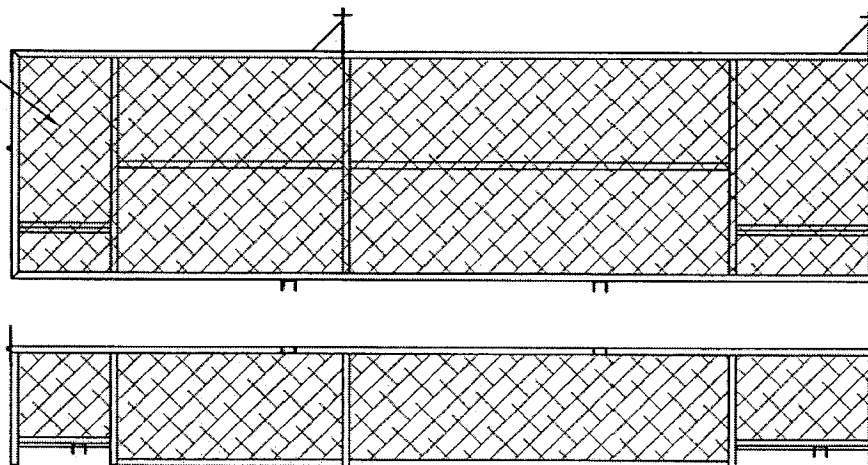
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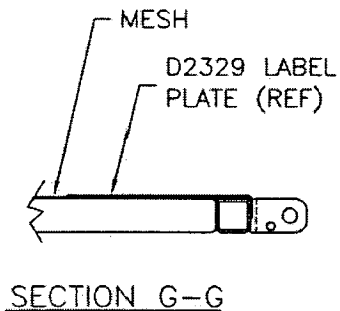
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| DATE | 05.11.10 | TITLE | BASKET ASSEMBLY (206L) | REV. E SHEET 4 OF 5 |
| | | SCALE | NTS | |



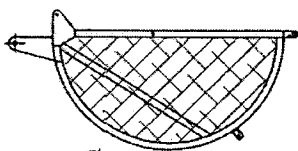
D2252-043 LID ASSEMBLY



D2252-041 BASKET ASSEMBLY



SKIN WITH 3/4-16 F
EXPANDED SS, TACK
WELD EACH STRAND
END TO FRAME



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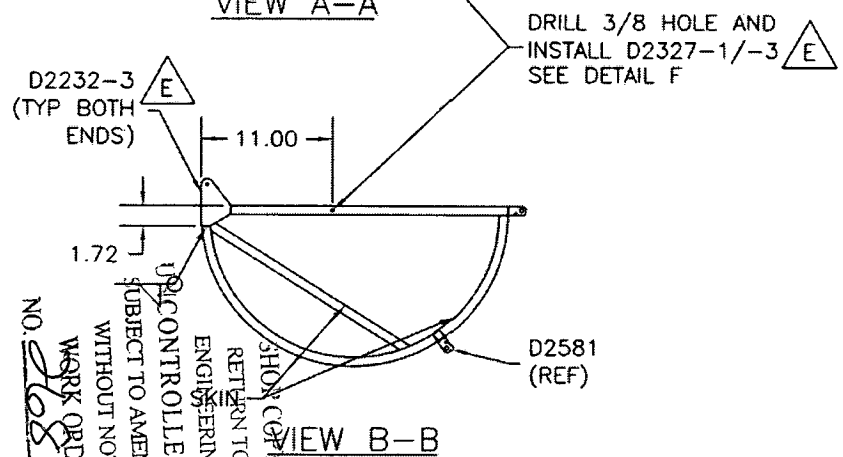
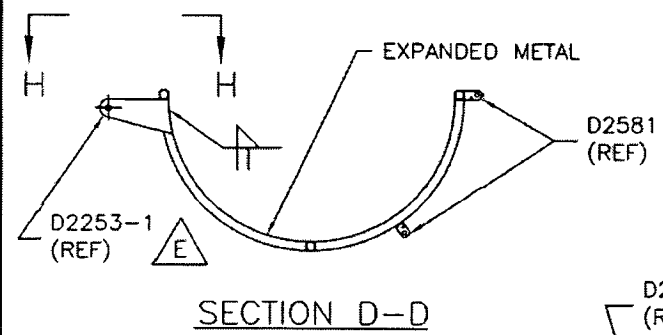
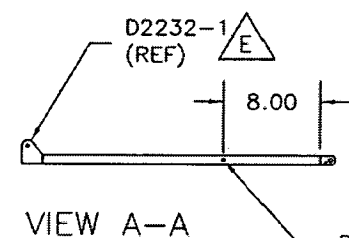
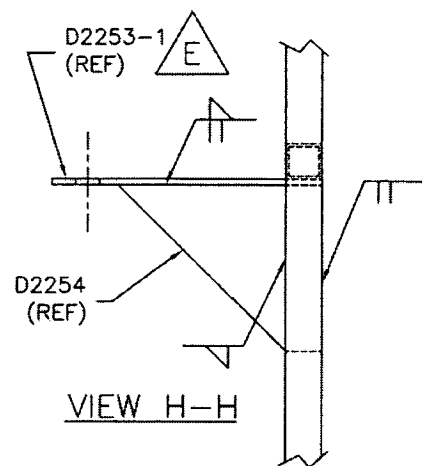
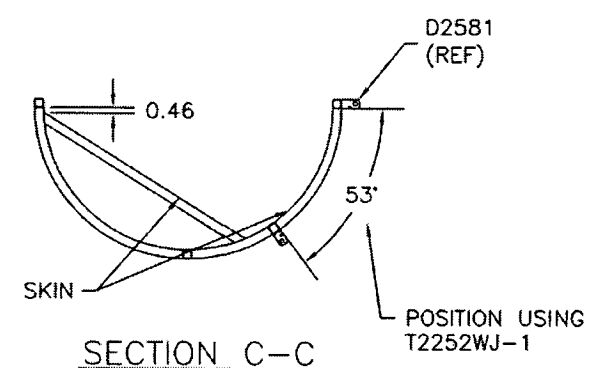
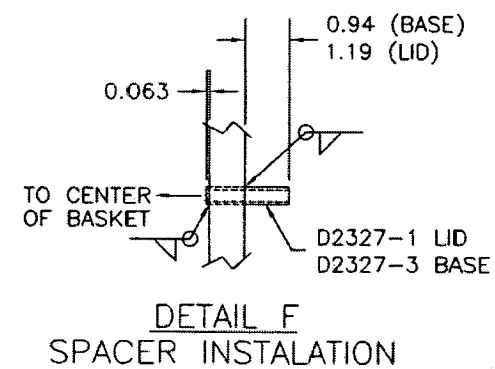
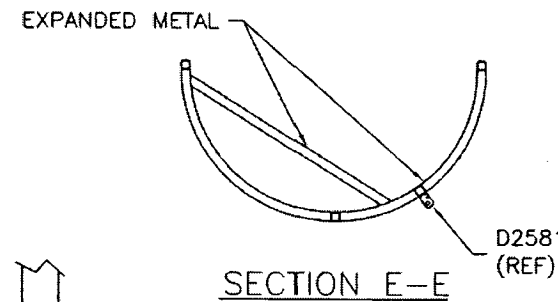
WORK ORDER
26878

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| CHECKED | | APPROVED | | DRAWING NO. D2252 |
| DATE | 05.11.10 | TITLE | BASKET ASSEMBLY (206L) | REV. E SHEET 5 OF 5 |
| | | SCALE | NTS | |



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